

Date: Thursday, 11/9/2006 4:37:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 29387	
Estimate Number : 10219	
P.O. Number : N/A	Part Number : D219923
This Issue : 11/9/2006 S.O. No. : N/A	Drawing Number : D2199 REV. E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E1
Previous Run : N/A	Material : N/A
Written By : <u>JA 06/11/10</u>	Due Date : 11/25/2006 Qty: 10 Um: Each
Checked & Approved By : <u>JA 06/11/10</u>	
Comment : Est:D 02.06.10 Rem polish & add finishNG/CC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 2.3100 f(s)/Unit Total: 23.1000 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M102273

SB 06/12/07 (10)

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 06/12/07 (10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06/12/07 (10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

AD 06/12/17 (10)

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

4/18 06/12/28 (10)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT

4/6 06/12/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/02

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 29387

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51222

JD 6/12/29 @

PN 2/06/2

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/02

Job Completion



C 207101102

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

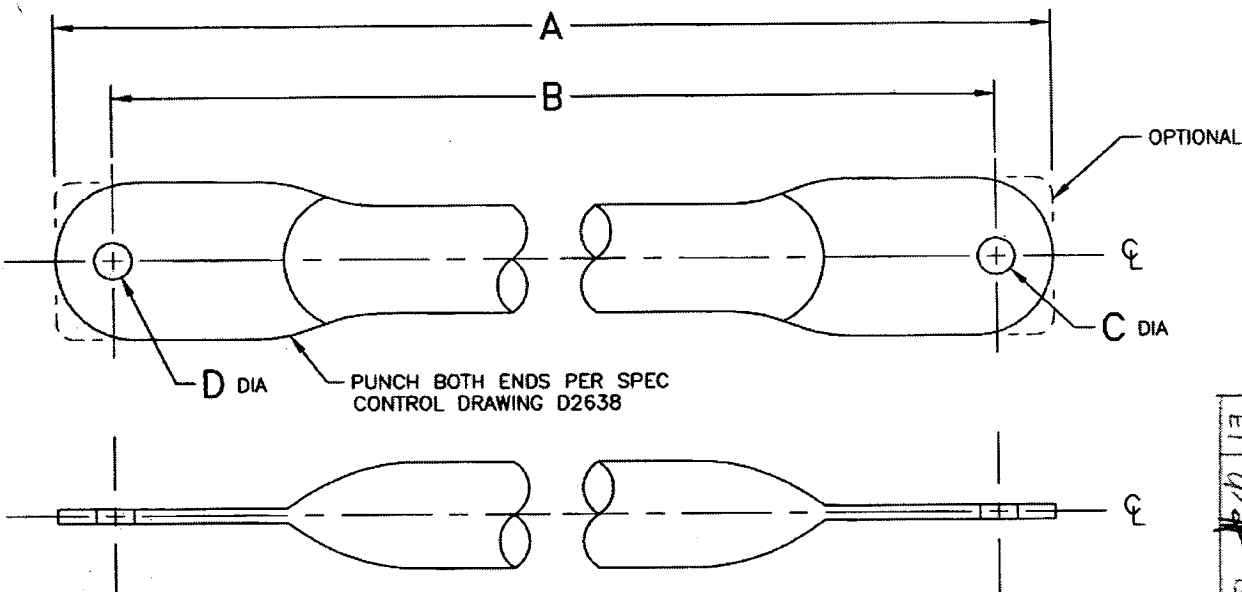
DART



RELEASED
48.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
98.04.28		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	02.03.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

00.10.13
00.10.13

NOTES:

- MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
- MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
- FINISH: POWDER COAT WHITE (43.5.2) PER DART QSI 005 4.3/E1

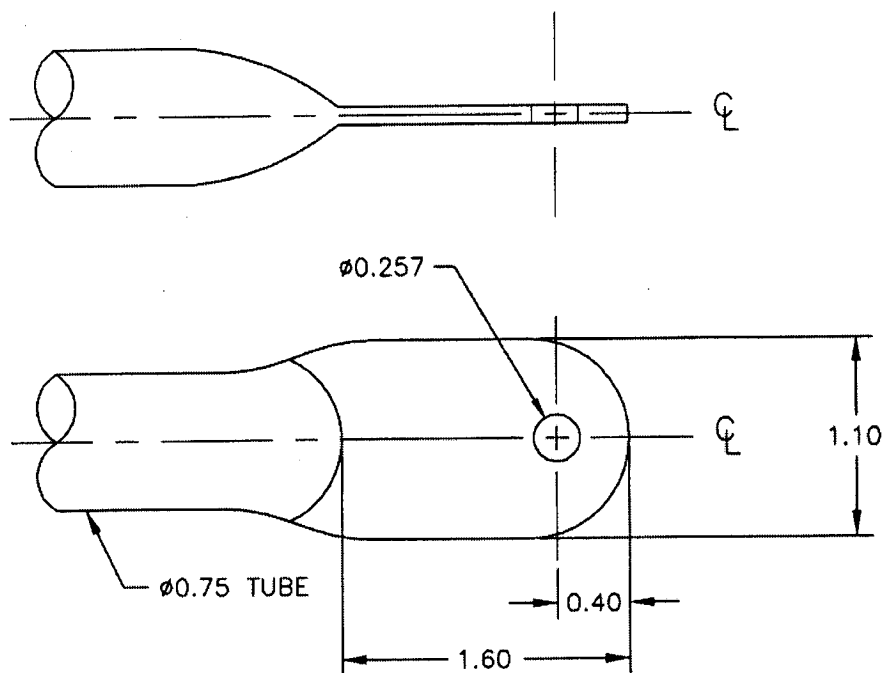
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WORK ORDER
NO. 29387



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
94/09/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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